

Work Order ID 164031

Tuesday, July 11, 2017 12:47:15 PM

164031

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Item ID: D5090-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Duct Assembly
 Start Date: 7/13/2017 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 7/28/2017 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: W Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D5090	D								

110 0.00 ***110*** 10 Ø JUL 24 2017 **DAS 19 9-09**

Small Fab

Memo

4.03

1- CHECK MESUREMENTS BEFORE ASSEMBLING BRACKETS AS PER DWG BY PUTING CLEKOS.

2- ASSEMBLE AS PER DWG AND FILL UPPER AND LOWER GAPS AS SHOWN ON DWG WITH PROSEAL OR SIKAFLEX.

PROSEAL BATCH# _____ OR SIKAFLEX

BATCH: 137946

120 QC5- Inspect part completeness to step on W/O 0.00

120

QC

Memo

0.20

Quality Control

10 Ø JUL 25 2017 **DAS 38 9-09**

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>51222B</u>	0.00							
130									
Packaging	Memo	0.10							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	1.00							
Quality Control									

10 JUL 26 2017 ^{DAS} 6 ₉₋₈₉

17/7/28

JUL 27 2017

Picklist Print

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164031

Parent Item: D5090-041

D5090-041

Parent Item Name: Duct Assembly

Start Date: 7/13/2017

Required Date: 7/28/2017

Start Qty: 10.00

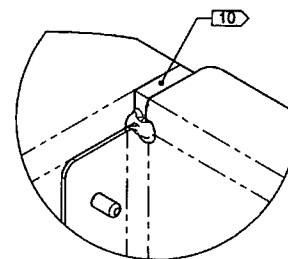
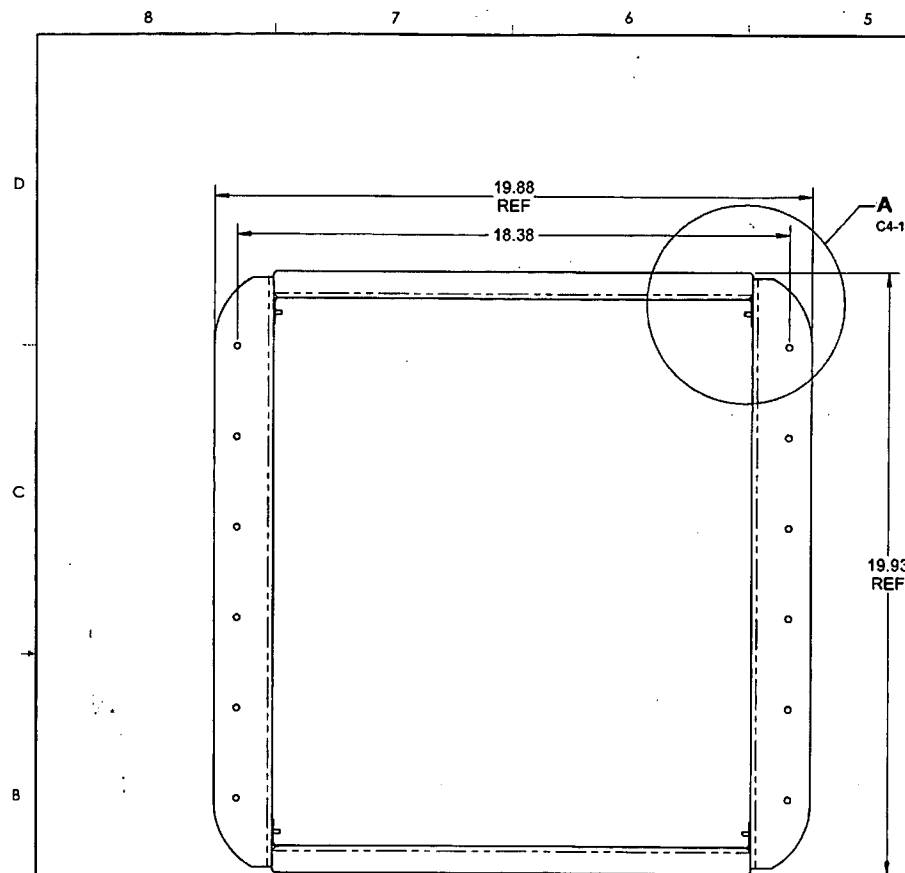
Required Qty: 10.00

Comments: IPP REV:A 14.06.18 NEW ISSUE DD VERF:JLM

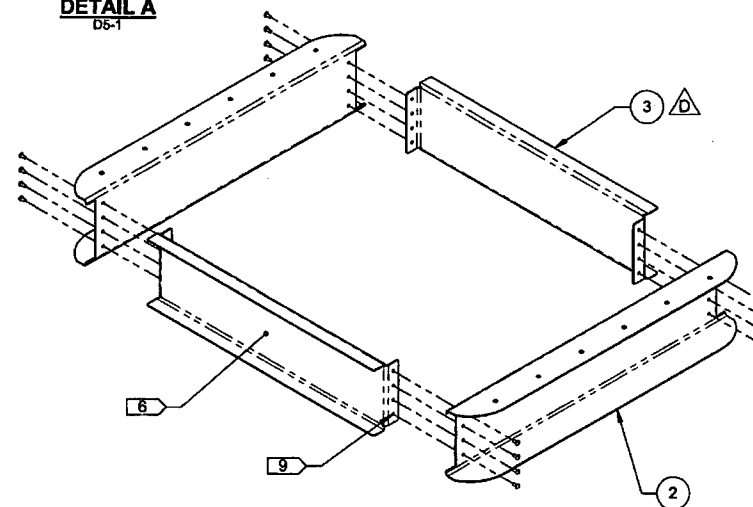
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D5090-1		Manufactured	No			110	Each	0.0000	2	20			DAS
D5090-1								(20)	**			JUL 24 2017	19 9-89
Bracket													
D5090-3		Manufactured	No			110	Each	0.0000	2	20			DAS
D5090-3								(20)	**			JUL 24 2017	19 9-89
Bracket													
MS20470AD4-5		Purchased	No			110	Each	1,505.000	16	160			DAS
MS20470AD4-5									**			JUL 24 2017	19 9-89
RIVET, UNIVERSAL HEAD													

Location	Loc Qty	Loc Code
GA	809	
m136851	809	
ST310	696	
m136851	696	

(132803) (37)
(138072) (123)



DETAIL A
D5-1



ITEM	QTY	P/N	DESCRIPTION
1	X	D5090-041	DUCT ASSEMBLY
2	2	D5090-1	BRACKET
3	2	D5090-3	BRACKET
4	16	MS20470AD4-5	RIVET, SOLID, PAN HEAD

D5090-041 DUCT ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 AFTER TRANSFER DRILLING
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 1.86 lbs
- 8) ASSEMBLE D5090-041 WITH CLECO CLAMPS AND VERIFY DIMENSIONS
- 9) INSTALL MS20470AD4-5 RIVETS
- 10) FILL UPPER AND LOWER GAPS WITH SIKAFLEX, PROSEAL 890 OR EQUIVALENT, 4 PL

D	REMOVED Ø0.201 HOLES FROM -3F, REF CAR17-169	RF	17.06.16
C	REVISED D5090-1 DIMENSION (ZN C4-2), REVISED D5090-1 GEOMETRY (ZN C2-2 AND ZN C5-2), REVISED NOTE 7 (ZN A8-2 AND ZN A8-3), REVISED D5090-3 DIMENSION (ZN C3-4), ADDED DETAIL A (ZN C4-1), REVISED NOTE 10 (ZN A8-1), REMOVED FLAG NOTE FROM TOP VIEW (ZN C7-1)	AK	14.11.25
B	REVISED D5090-3 TO ADD HOLES (ZN C6-4, ZN B5-5)	AK	14.08.27
A	NEW ISSUE	AK	14.04.01
REV.	DESCRIPTION	BY	DATE

DESIGN	AK	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	VS	DRAWING NO.	REV. D
MFG. APPR.	DD	D5090	SHEET 1 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	DUCT ASSEMBLY	NTS
DATE	17.06.16	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

RELEASED
2017-07-06
EW 17-582

APPROVED